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(54) **HONEYCOMB STRUCTURAL BODY**

(57) A honeycomb structure (10), having a large number of through-holes (11) formed in the axial direction and defined by partition walls, wherein slits (12) are formed so as to be exposed to at least part of the outer surface (13) of the honeycomb structure along the axial direction. In this honeycomb structure, each portion can deform freely without being restricted by other portion even when an uneven temperature distribution appears therein; as a result, reduction in thermal stress is possible and generation of cracks can be prevented.

FIG. 4(a)

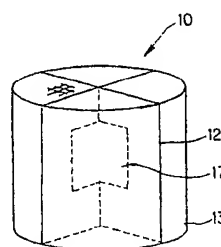


FIG. 4(b)

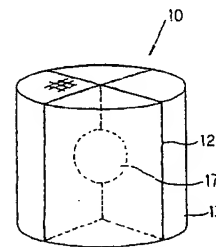


FIG. 4(c)

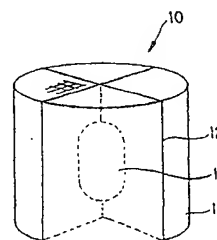
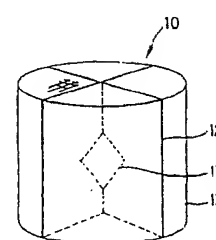


FIG. 4(d)



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Description

Technical Field

[0001] The present invention relates to a honeycomb structure for catalyst loading, used in an exhaust gas purifier of a heat engine (e.g. an internal combustion engine) or a burner (e.g. a boiler), a reforming unit of a liquid fuel or a gaseous fuel, and the like; as well as to a honeycomb structure used as a filter.

Background Art

[0002] Honeycomb structures having a catalyst component loaded thereon have been used in an exhaust gas purifier of a heat engine (e.g. an internal combustion engine) or a burner (e.g. a boiler), a reforming unit of a liquid fuel or a gaseous fuel, and the like. It is known that honeycomb structures are also used as a filter for capturing and removing the particulate matter contained in a dust-containing fluid such as exhaust gas emitted from a diesel engine.

[0003] The honeycomb structures used for such purposes have had problems; for example, they undergo rapid temperature change or local heating by the action of an exhaust gas, an uneven temperature distribution appears therein, resultantly they come to have cracks. Particularly when they were used as a filter for capturing the particulate matter contained in the exhaust gas emitted from a diesel engine, cracks appeared easily because the carbon fine particles accumulated on the filter must be burnt for removal and it inevitably causes local heating to high temperatures and easily generates a large thermal stress. In this case, the thermal stress is generated because the uneven temperature distribution allows different portions of the honeycomb structure to have different thermal expansion deformations and resultantly each portion is restricted by each other and is unable to make free deformation.

[0004] To reduce the stress, there was proposed, in, for example, JP-A-59-199586, a honeycomb structure having a large number of through-holes each surrounded by partition walls, wherein partition wall areas having at least one slit are formed at given portions of the honeycomb structure almost uniformly.

[0005] In this proposal, small slits are distributed uniformly in a honeycomb structure, thereby the rigidity of the total honeycomb structure is reduced and the freedom of deformation is increased, therefore an effect of stress reduction is achieved. However, the degree of an increase in the freedom of deformation is insufficient; therefore, the above proposal for stress reduction was insufficient for a honeycomb structure used under severe conditions where the unevenness of temperature distribution becomes larger.

[0006] In view of the above-mentioned problems of the prior art, the present invention aims at providing a honeycomb structure which gives no cracks by thermal stress during use and which is superior in durability.

Disclosure of the Invention

[0007] According to the present invention there is provided a honeycomb structure having a large number of through-holes formed in the axial direction and defined by partition walls, wherein slits are formed so as to be exposed to at least part of the outer surface of the honeycomb structure along the axial direction.

[0008] In the above honeycomb structure, the slits are formed preferably in parallel to the direction of the through-holes. Also, preferably, the slits are formed at least at one end surface at least at the edge. By forming the slits in this way, each portion of the honeycomb structure can deform freely without being restricted by other portion even when an uneven temperature distribution appears therein; as a result, reduction in thermal stress is possible and generation of cracks can be prevented.

[0009] In this case, more preferably, the length of each slit formed at the edge of one end surface is, in the axial direction of the outer surface, 10% or more of the total length of the honeycomb structure and, at the end surface, 10% or more of the diameter of the honeycomb structure.

[0010] It is also preferable that each slit is exposed to at least one end surface so as to connect the two points of the end surface edge, because such a honeycomb structure has an increased freedom for deformation in the vicinity of the end surface, reduction in thermal stress is possible, and generation of cracks is prevented. In this case, more preferably, the length of each slit is, in the axial direction of the outer surface, 10% or more of the total length of the honeycomb structure and, at the end surface, 10% or more of the diameter of the honeycomb structure.

[0011] When the present honeycomb structure is used under such conditions that the total (total length) of the honeycomb structure comes to have a temperature unevenness, it is preferable that each slit is exposed to the outer surface over its total length in the through-hole direction.

[0012] When the total of the honeycomb structure comes to have a large temperature unevenness, it is particularly preferable that each slit is formed so that in each section of the honeycomb structure including each slit there is a continuous area in which no slit is formed and which is not exposed to the outer surface of the honeycomb structure.

[0013] In the honeycomb structure of the present invention, it is preferable that in the honeycomb structure section

which is normal to the through-holes and in which the length of each slit is largest, the length of each slit is 10% or more, preferably 30% or more of the distance between the outer surface along the axial direction and the center of the honeycomb structure.

[0014] In the honeycomb structure of the present invention, it is preferable that each slit is filled with a filler. It is also preferable that the present honeycomb structure is a combination of two or more honeycomb segments.

[0015] The above honeycomb structure is preferably made of a material containing, as a main crystal phase, at least one kind selected from the group consisting of cordierite, SiC, SiN, alumina, mullite, aluminum titanate and lithium aluminum silicate.

[0016] Preferably, the present honeycomb structure loads thereon a metal having a catalytic action and is usable for purification of the exhaust gas emitted from a heat engine (e.g. an internal combustion engine), a burner (e.g. a boiler) or the like, or for reforming of a liquid fuel or a gaseous fuel. The metal having a catalytic action is preferably at least one kind selected from Pt, Pd and Rh.

[0017] In the present honeycomb structure, the sectional shape of the through-holes is preferably any of a triangle, a tetragon, a hexagon and a corrugation from the standpoint of the production of the honeycomb structure.

[0018] When the present honeycomb structure is used as a filter for capturing and removing the particulate matter contained in a dust-containing fluid, for example, as a particulate filter for diesel engine, it is preferable that the partition walls surrounding the through-holes have a filtration ability, a given proportion of the through-holes are blocked at one end and the remaining through-holes are blocked at other end.

[0019] In the present invention, "the outer surface of the honeycomb structure" refers to the whole outer surface of the honeycomb structure and includes not only the outer surface along the axial direction but also the end surfaces.

Brief Description of the Drawings

[0020]

Fig. 1 is perspective views showing examples of the honeycomb structure according to the present invention.

Fig. 2 is perspective views showing other examples of the honeycomb structure according to the present invention.

Fig. 3 is perspective views showing still other examples of the honeycomb structure according to the present invention.

Fig. 4 is perspective views showing still other examples of the honeycomb structure according to the present invention.

Fig. 5 is perspective views showing still other examples of the honeycomb structure according to the present invention.

Fig. 6(a) is a perspective view showing still other example of the honeycomb structure according to the present invention. Fig. 6(b) is a view taken along the Y-Y section of Fig. 6(a).

Fig. 7(b) is a perspective view showing still other example of the honeycomb structure according to the present invention. Fig. 7(b) is a view taken along the Z-Z section of Fig. 7(a).

Fig. 8(a) shows a method for slit formation and indicates a state in which slits are formed in parallel to partition walls. Fig. 8(b) indicates a state in which slits are formed so as to cut partition walls obliquely.

Fig. 9(a) shows a stress-relaxing mechanism provided at the front end of each slit, i.e. a stress-relaxing portion having a curvature provided at the front end of each slit. Fig. 9(b) shows branches provided at the front end of each slit.

Fig. 10(a) shows a form of slit formed by cutting part of partition walls. Fig. 10(b) shows a form of slit formed by removing part of partition walls.

Fig. 11(a) is a plan view showing an example of the disposition of slits in the honeycomb structure of the present invention; Fig. 11(b) is a front view of the example; Fig. 11(c) is a side view of the example; and Fig. 11(d) is a bottom view of the example.

Best Mode for Carrying Out the Invention

[0021] The honeycomb structure of the present invention has a large number of through-holes formed in the axial direction and defined by partition walls, wherein slits are formed so as to be exposed to at least part of the outer surface of the honeycomb structure. Therefore, the present honeycomb structure generates no cracks by the thermal stress appearing during the use and is extremely superior in durability.

[0022] The present invention is described in more detail below with reference to the embodiments shown in the accompanying drawings. However, the present invention is in no way restricted to these embodiments.

[0023] Figs. 1(a), (b), (c) and (d) are perspective views showing embodiments of the honeycomb structure of the present invention.

[0024] In Figs. 1(a), (b), (c) and (d), 10 is a honeycomb structure. The honeycomb structure 10 has a large number of through-holes 11 formed in the axial direction [an X direction in Figs. 1(a), (b), (c) and (d)] and defined by partition walls. In the honeycomb structure 10, four slits 12 are formed so as to be exposed to part of the outer surface 13 along the axial direction and be parallel to the direction of the through-holes 11. Each slit 12 is formed so as to cross the edge 15 of the end surface 14.

[0025] In Fig. 1(a), four slits 12 are formed so as to cross the edge 15 of the end surface 14 and each in the shape of a triangle. In Fig. 1(b), each slit 12 is formed in the shape of a tetragon. In Fig. 1(c), each slit 12 is formed so as to be exposed to the axial direction total length of the outer surface 13 along the axial direction of the honeycomb structure 10 and so that the depth of the slit 12 becomes gradually smaller and each slit has a triangular shape. In Fig. 1(d), each slit 12 is formed so as to be exposed to the axial direction total length of the outer surface 13 along the axial direction of the honeycomb structure 10 and so that the depth of the slit 12 becomes constant in the axial direction of the honeycomb structure 10. By forming slits 12 as shown in Figs. 1(a), (b), (c) and (d), each portion of the honeycomb structure 10 can deform freely without being restricted by other portion even when an uneven temperature distribution appears in the honeycomb structure 10 (that is, temperature difference exists between the portions of the honeycomb structure 10); thereby, the thermal stress is reduced; and generation of cracks is minimized.

[0026] In Fig. 2(a), three slits 12 are formed. As in Fig. 1(c), each slit 12 is formed so as to be exposed to the axial direction total length of the outer surface 13 along the axial direction of the honeycomb structure 10 and so that the depth of the slit 12 becomes gradually smaller and each slit has a triangular shape. In Fig. 2(b), three slits 12 are formed and, as in Fig. 1(d), each slit 12 is formed so as to be exposed to the axial direction total length of the outer surface 13 along the axial direction of the honeycomb structure 10 and so that the depth of the slit 12 becomes constant in the axial direction of the honeycomb structure 10. These embodiments are particularly effective when the honeycomb structure is used under such conditions that an uneven temperature distribution appears over the total length of the honeycomb structure.

[0027] Figs. 3(a) and (b) are perspective views showing other examples of the honeycomb structure of the present invention.

[0028] In the example of Fig. 3(a), slits 12 are formed so as to be exposed to one end surface 14 and connect the two points (A and B) or (C and D) of an end surface edge 15. In the example of Fig. 3(b), slits 12 are formed at two end surfaces 14 and 16 so as to be exposed to each of them and connect each two points of an end surface edge 15.

[0029] Figs. 4(a), (b), (c) and (d) are perspective views showing still other examples of the honeycomb structure of the present invention.

[0030] In each example of Figs. 4(a), (b), (c) and (d), in each section of a honeycomb structure 10 including a slit 12 there is a continuous area 17 having no slit 12 formed, in the center of the honeycomb structure 10. This continuous area 17 is not exposed to the outer surface of the honeycomb structure, that is, any of the outer surface 13 along the axial direction, the upper end surface 14 and the lower end surface 16. Incidentally, the shape of the continuous area 17 is a rectangle in Fig. 4(a), a circle in Fig. 4(b), a racetrack in Fig. 4(c) and an equilateral tetragon in Fig. 4(d). By forming a honeycomb structure in such a constitution, no cracks are generated in the honeycomb structure even when a large temperature unevenness (for example, large temperature difference between the portions of the honeycomb structure) appears in the whole honeycomb structure.

[0031] In each example of Figs. 5(a), (b), (c) and (d), in each section of a honeycomb structure 10 including a slit 12 there is a continuous area 17 having no slit 12 formed and part of the continuous area 17 is exposed to the lower end surface 16 of the honeycomb structure 10.

[0032] Figs. 6(a) and (b) and Figs. 7(a) and (b) are other examples in which a continuous area is not exposed to the outer surface of a honeycomb structure. Fig. 6(a) is a perspective view and Fig. 6(b) is a sectional view taken along the Y-Y section of Fig. 6(a). Fig. 7(a) is a perspective view and Fig. 7(b) is a sectional view taken along the Z-Z section of Fig. 7(a).

[0033] In the example of Figs. 6(a) and (b), the shape of a continuous area 17 is a rectangle as in Fig. 4(a), and the continuous area 17 is not exposed to the outer surface of the honeycomb structure 10. In this example, however, the number of slits 12 is larger than in Fig. 4(a). In the example of Fig. 7(a) and (b), the shape of a continuous area 17 is an ellipse, and the continuous area 17 is not exposed to the outer surface of the honeycomb structure 10.

[0034] Next, the constituent features of the honeycomb structure of the present invention are described in more detail.

[0035] In the honeycomb structure of the present invention, the length of each slit is preferably 10% or more, more preferably 30% or more of the distance between the outer surface along the axial direction and the center of the honeycomb structure, in a honeycomb structure section which is normal to the through-holes and in which the length of the slit becomes largest.

[0036] In the honeycomb structure of the present invention, slits are preferably formed in point symmetry in a honeycomb structure section normal to the through-holes because deformation occurs in the honeycomb structure with substantially no partiality. However, slit formation is not restricted thereto and slits 12 may be disposed, for example, as shown in Figs. 11 (a) to (d).

[0037] Slits 12 may be formed so as to cut partition walls 20 obliquely (not in parallel thereto), as shown in Fig. 8(b). However, slits are preferably formed in parallel to partition walls 20, as shown in Fig. 8(a), because the stress concentration at the front end of each slit 12 is small.

[0038] When the sectional shape of the through-holes 11 of the honeycomb structure 10 is a triangle, slits 12 are preferably in a direction of 60° or 120°, for the same reason as mentioned above.

[0039] The width of each slit 12 is not critical and can be determined as desired. However, the width is desirably smaller than the width of each through-hole because too large a slit width incurs increases in filling steps and filling amount of filler and a decrease in the number of cells usable for purification of fluid (e.g. gas).

[0040] Further in the honeycomb structure 10 of the present invention, it is preferable for relaxation of thermal stress to form, at the front end of each slit 12, a branch part 21 formed by branching, as shown in Fig. 9(b), or a stress relaxation part 22 having a curvature, as shown in Fig. 9(a).

[0041] The form of each slit 12 may be a form obtained by partially cutting partition walls 20 of a honeycomb structure 10, as shown in Fig. 10(a), or a form obtained by partially removing partition walls 20, as shown in Fig. 10(b).

[0042] In the honeycomb structure of the present invention, the sectional shape of each through-hole may be various, for example, a circle, an ellipse and a racetrack.

[0043] The honeycomb structure of the present invention is preferably a combination of two or more honeycomb segments. The material constituting the present honeycomb structure preferably contains, as a main crystal phase, at least one kind selected from the group consisting of cordierite, SiC, SiN, alumina, mullite, aluminum titanate and lithium aluminum silicate. SiC of high thermal conductivity is particularly preferred because it releases the absorbed heat easily.

[0044] The density of the cells surrounded by partition walls is preferably 6 to 2,000 cells/in.² (0.9 to 311 cells/cm²), more preferably 50 to 400 cells/in.² (7.8 to 62 cells/cm²). When the cell density is less than 6 cells/in.² (0.9 cell/cm²), the resulting honeycomb segments are insufficient in strength and effective GSA (geometrical surface area); when the cell density is more than 2,000 cell/in.² (311 cells/cm²), the resulting honeycomb segments show a large pressure loss when a gas flows therethrough.

[0045] The sectional shape of the through-holes, i.e. the cell shape is preferably any of a triangle, a tetragon and a hexagon from the standpoint of honeycomb production.

[0046] With respect to the filler used for filling the slits formed in the honeycomb structure, a ceramic fiber, a ceramic powder, a cement, etc. all having heat resistance are preferably used singly or in admixture. As necessary, an organic binder, an inorganic binder, etc. may be mixed with the filler.

[0047] When the honeycomb structure of the present invention is used as a catalyst carrier for purification of the exhaust gas emitted from a heat engine (e.g. an internal combustion engine) or a burner (e.g. a boiler), or for reforming of a liquid fuel or a gaseous fuel, a metal having a catalytic activity is loaded on the honeycomb segments constituting the honeycomb structure. As representative metals having a catalytic activity, there can be mentioned Pt, Pd and Rh. At least one kind of these metals is preferably loaded on the honeycomb segments.

[0048] Meanwhile, when the honeycomb structure of the present invention is used as a filter for capturing and removing the particulate matter contained in a dust-containing fluid, for example, a particulate filter for diesel engine, the honeycomb structure preferably has such a structure that the partition walls surrounding the through-holes has a filtration ability, given proportions of the through-holes are blocked at one end, and the remaining through-holes are blocked at other end.

[0049] When a dust-containing fluid is allowed to enter such a honeycomb structure from one end surface, the dust-containing fluid enters the inside of the honeycomb structure from those through-holes not blocked at the above end surface, passes through the partition walls having a filtration ability, and enters other through-holes not blocked at other end surface. During the period in which the dust-containing fluid passes through the partition walls, the particulate matter contained in the fluid is captured by the partition walls, and a particulate matter-free, purified fluid is discharged from the other end surface of the honeycomb structure.

[0050] As the accumulation of the captured particulate matter on the partition walls proceeds, plugging appears, which reduces the filtration ability of the honeycomb structure. Therefore, the honeycomb structure is periodically heated using a means such as heater or the like, whereby the captured particulate matter are burnt completely and the filtration ability is revitalized. In order to promote the burning of the particulate matter during the revitalization, it is possible to allow the honeycomb structure to load the above-mentioned metal having a catalytic action.

[0051] The present invention is described in more detail below by way of Examples. However, the present invention is not restricted to these Examples.

Example 1

[0052] By using a SiC-made honeycomb structure having a size of 144 mm (diameter) and 152 mm, a partition wall thickness of 0.3 mm and a cell density of 31 cells/cm² and by blocking given proportions of the through-holes at one end and the remaining through-holes at other end, there were produced honeycomb structures each as a particulate

filter for purification of diesel engine exhaust gas. They were produced so as to have slits as shown in Fig. 1(a), Fig. 1(d) Fig. 3(a), Fig. 3(b), Fig. 4(a), Fig. 4(b) or Fig. 7, or so as to have no slit (a basic honeycomb structure). In the honeycomb structures of Figs. 1(a) and 1(d), the length of each slit at the upper end surface 14 was 1/2 of the radius of the honeycomb structure 10. In the honeycomb structures of Figs. 1(a) and 3(a), the axial direction length of each slit at the outer surface 13 was 20 mm; in the honeycomb structure of Fig. 3(b), the axial direction outer surface length of each slit formed at the upper end surface 14 was 15 mm and the axial direction outer surface length of each slit formed at the lower end surface 16 was 30 mm.

[0053] In the thus-produced honeycomb structures, those cells in which slits were formed, were sealed with a filler; then, a ceramic-made non-expansion mat (as a holding member) was wound round the periphery of each honeycomb structure; the resulting honeycomb structure was forced into a SUS 409-made canning case to produce various canning structures. These canning structures were each subjected to the following filter revitalization test. That is, a soot-containing combustion gas generated by burning of a gas oil for diesel engine was allowed to flow into each honeycomb structure from the lower end surface (the lower end surface in each Drawing) and leave from the upper end surface, whereby the soot in the combustion gas was captured inside the honeycomb structure. The soot-captured honeycomb structure was allowed to cool to room temperature, after which a combustion gas containing a given proportion of oxygen was allowed to flow into the honeycomb structure from the lower end surface at 800°C to completely burn the soot captured in the honeycomb structure.

[0054] The transition period necessary for elevating the inlet gas temperature to 800°C and the weight of the soot captured were each set at three levels, and the filter revitalization test was carried out. The appearance of cracks was examined at each site of the upper end surface (outlet), lower end surface (inlet), outer surface along axial direction and inside of each honeycomb structure. The results are shown in Table 1.

Table 1

Soot weight Transition period Site of cracks	Largest Shortest				Large Short				Standard			
	Inlet		Outlet		Inlet		Outlet		Inlet		Outlet	
	Inlet	Outlet	Inside	Outer surface	Inlet	Outlet	Inside	Outer surface	Inlet	Outlet	Inside	Outer surface
Fig. 1(a)	▲	▲	▲	▲	▲	○	○	▲	○	○	○	○
Fig. 1(d)	▲	▲	▲	▲	○	○	○	○	○	○	○	○
Fig. 3(a)	▲	○	▲	▲	▲	○	▲	▲	○	○	○	○
Fig. 3(b)	○	○	▲	▲	○	○	○	○	○	○	○	○
Fig. 4(a)	○	○	▲	▲	○	○	○	○	○	○	○	○
Fig. 4(b)	○	○	○	▲	○	○	○	○	○	○	○	○
Fig. 7	○	○	○	○	○	○	○	○	○	○	○	○
No slit	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	○	○

▲: Cracks generated.

○: No cracks.

[0055] As is clear from Table 1, even in the case of the standard conditions, cracks appeared in the honeycomb

structure having no slit, at the end surfaces (inlet and outlet). In contrast, no cracks appeared in the honeycomb structures of the present invention of Fig. 1(a), Fig. 1(d), Fig. 3(a), Fig. 3(b), Fig. 4(a), Fig. 4(b) and Fig. 7.

[0056] When the transition period was shortened and the weight of the soot captured was increased, temperature unevenness became larger and cracks appeared partially when slits were formed only in the vicinity of one end surface of honeycomb structure as in Fig. 1(a) or Fig. 3(a); however, substantially no cracks appeared when a continuous area was not exposed to the outer surface of honeycomb structure as in Fig. 4(b), and no cracks appeared when slits were formed in an increased number as in Fig. 7.

Example 2

[0057] Using honeycomb structures shown in Table 2, having the same shapes and sizes as in Example 1 except that the dispositions and lengths of slits were changed, a filter revitalization test of completely burning and removing the soot accumulated was carried out in the same manner as in Example 1. The results are shown in Table 2.

Table 2

Sample No.	1	2	3	4
Structure	Fig. 1(a)	Fig. 3(a)	Fig. 1(a)	Fig. 3(a)
Slit length at end surface	50 mm	15 mm	15 mm	5 mm
Slit length at outer surface	30 mm	15 mm	5 mm	5 mm
Weight of soot captured				
10 g/L	○	○	○	○
12 g/L	○	○	○	X
14 g/L	○	○	X	X
16 g/L	○	○	X	X
18 g/L	○	○	X	X
20 g/L	○	X	X	X
○: No cracks. X: Cracks appeared. g/L: gram/liter.				

[0058] As is clear from the results of Table 2, an increase in weight of soot captured results in an increase in cracks formed when the lengths of slit at end surface and outer surface are smaller than given levels.

[0059] As described above, in the honeycomb structure of the present invention, each portion of the honeycomb structure can deform freely without being restricted by other portion even when there is an uneven temperature distribution in the honeycomb structure and, therefore, reduction in thermal stress is possible; as a result, generation of cracks can be prevented.

Claims

1. A honeycomb structure having a large number of through-holes formed in the axial direction and defined by partition walls, wherein slits are formed so as to be exposed to at least part of the outer surface of the honeycomb structure along the axial direction.
2. A honeycomb structure according to Claim 1, wherein the slits are formed in parallel to the direction of the through-holes.
3. A honeycomb structure according to Claim 1, wherein the slits are formed at least at one end surface at least at the edge.
4. A honeycomb structure according to Claim 3, wherein the length of each slit formed at the edge of one end surface is, in the axial direction of the outer surface, 10% or more of the total length of the honeycomb structure and, at the end surface, 10% or more of the diameter of the honeycomb structure.

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5. A honeycomb structure according to any of Claims 1 to 3, wherein each slit is exposed to at least one end surface so as to connect the two points of the end surface edge.
6. A honeycomb structure according to Claim 5, wherein the length of each slit is, in the axial direction of the outer surface, 10% or more of the total length of the honeycomb structure and, at the end surface, 10% or more of the diameter of the honeycomb structure.
7. A honeycomb structure according to any of Claims 1 to 6, wherein each slit is exposed to the outer surface over its total length in the through-hole direction.
8. A honeycomb structure according to any of Claims 1 to 7, wherein in each section of the honeycomb structure including each slit there is a continuous area in which no slit is formed and which is not exposed to the outer surface of the honeycomb structure.
9. A honeycomb structure according to any of Claims 1 to 8, wherein in the honeycomb structure section which is normal to the through-holes and in which the length of each slit is largest, the length of each slit is 10% or more of the distance between the outer surface along the axial direction and the center of the honeycomb structure.
10. A honeycomb structure according to any of Claims 1 to 9, wherein in the honeycomb section which is normal to the through-holes and in which the length of each slit is largest, the length of each slit is 30% or more of the distance between the outer surface along the axial direction and the center of the honeycomb structure.
11. A honeycomb structure according to any of Claims 1 to 10, wherein each slit is filled with a filler.
12. A honeycomb structure according to any of Claims 1 to 11, which is a combination of two or more honeycomb segments.
13. A honeycomb structure according to any of Claims 1 to 12, which is made of a material containing, as a main crystal phase, at least one kind selected from the group consisting of cordierite, SiC, SiN, alumina, mullite, aluminum titanate and lithium aluminum silicate.
14. A honeycomb structure according to any of Claims 1 to 13, which loads thereon a metal having a catalytic action and is usable for purification of the exhaust gas emitted from a heat engine or a burner, or for reforming of a liquid fuel or a gaseous fuel.
15. A honeycomb structure according to Claim 14, wherein the metal having a catalytic action is at least one kind selected from Pt, Pd and Rh.
16. A honeycomb structure according to any of Claims 1 to 15, wherein the sectional shape of the through-holes is any of a triangle, a tetragon, a hexagon and a corrugation.
17. A honeycomb structure according to any of Claims 1 to 16, wherein the partition walls surrounding the through-holes have a filtration ability, a given proportion of the through-holes are blocked at one end and the remaining through-holes are blocked at other end.
18. A honeycomb structure according to Claim 17, which is used as a filter for capturing and removing the particulate matter contained in a dust-containing fluid.

FIG. 1(a)

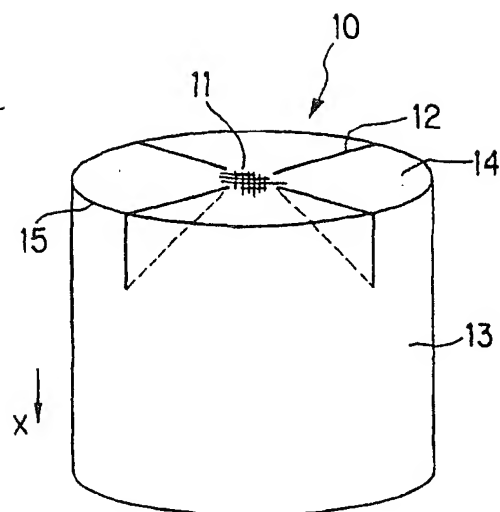


FIG. 1(c)

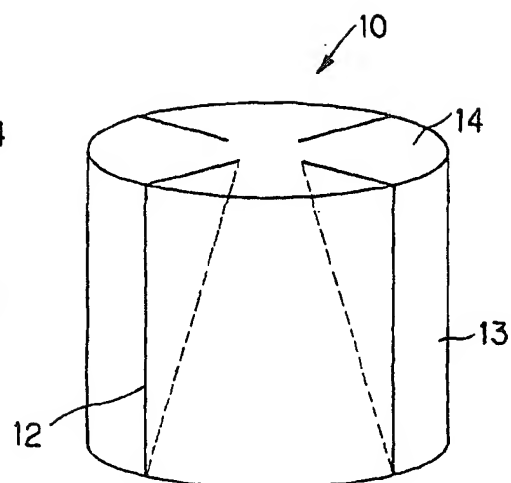


FIG. 1(b)

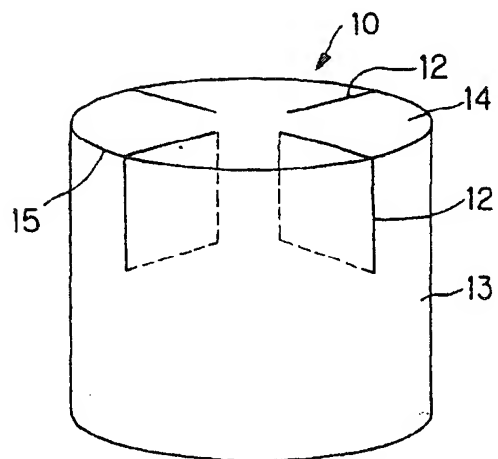


FIG. 1(d)

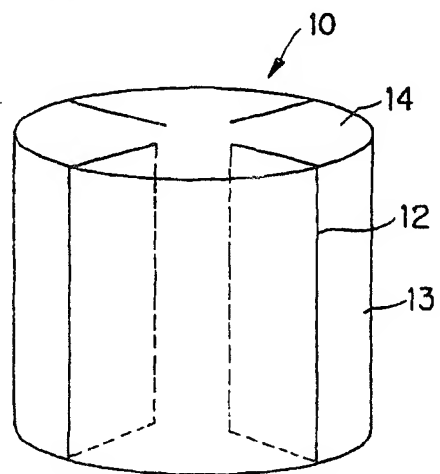


FIG. 2(a)

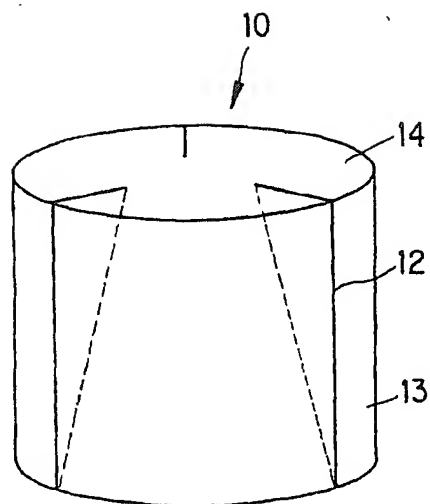


FIG. 2(b)

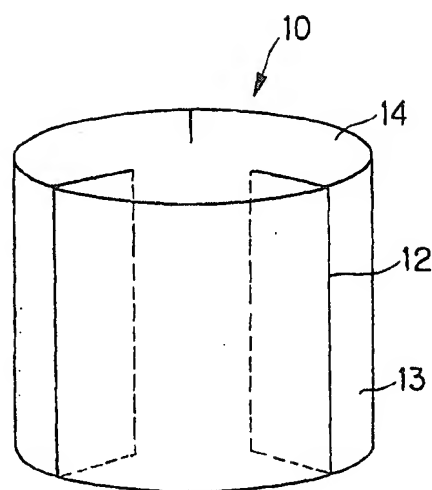


FIG. 3(a)

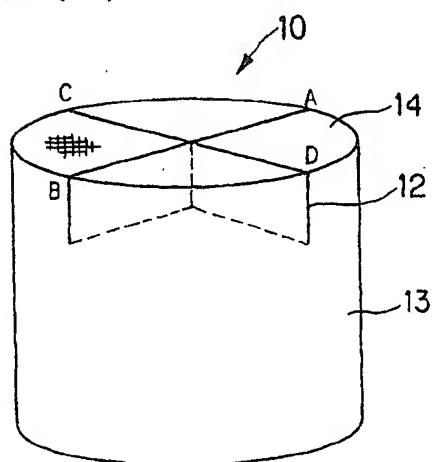


FIG. 3(b)

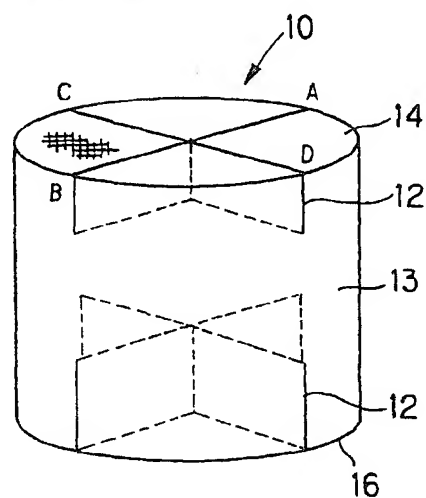


FIG. 4(a)

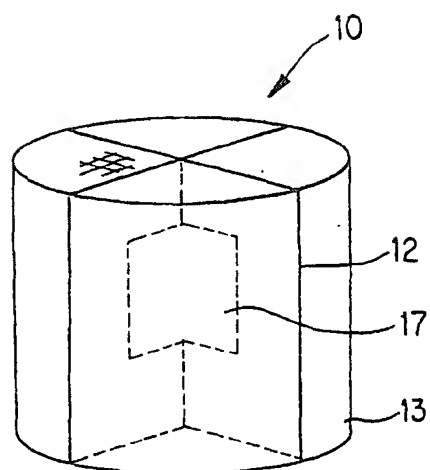


FIG. 4(b)

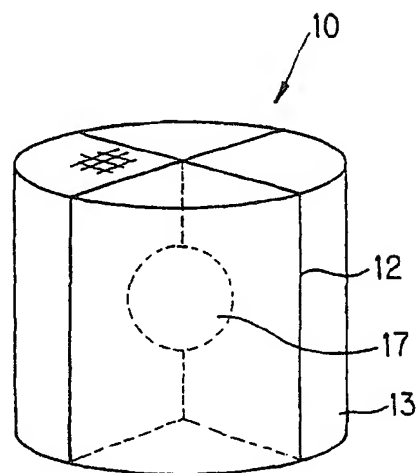


FIG. 4(c)

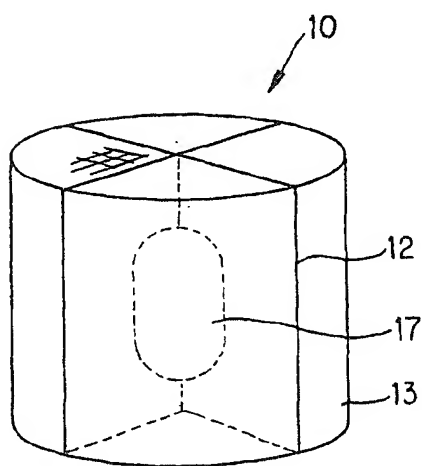


FIG. 4(d)

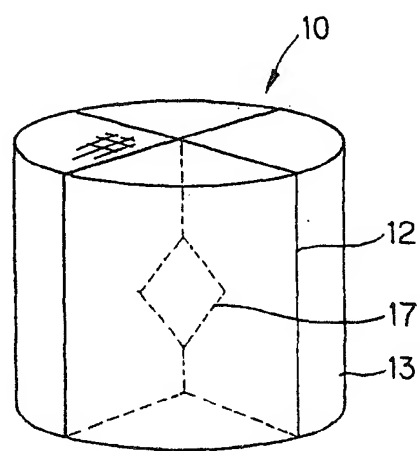


FIG. 5(a)

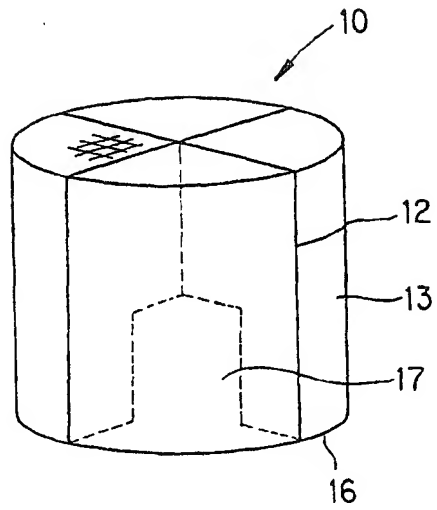


FIG. 5(b)

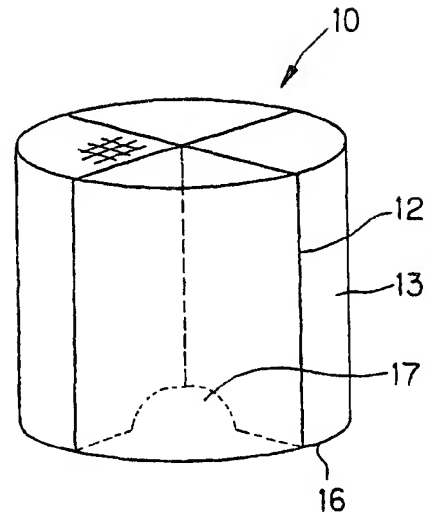


FIG. 5(c)

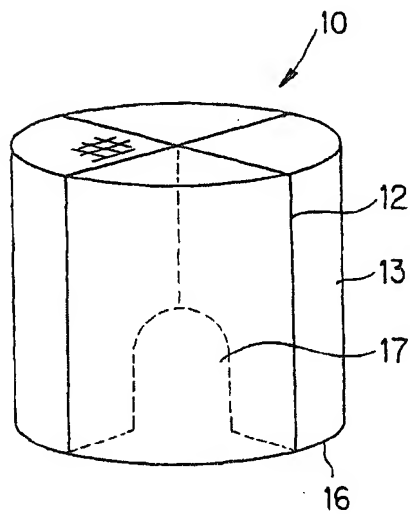


FIG. 5(d)

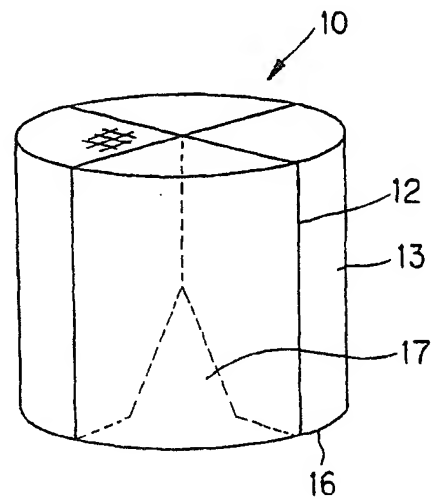


FIG. 6(a)

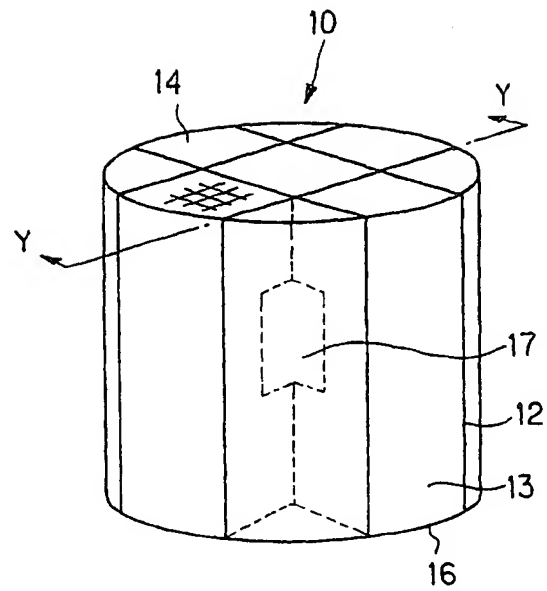


FIG. 6(b)

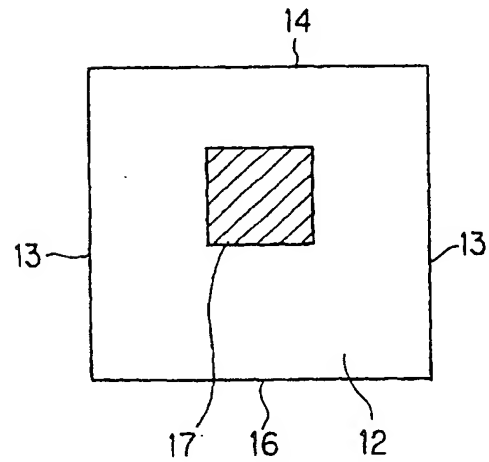


FIG. 7(a)

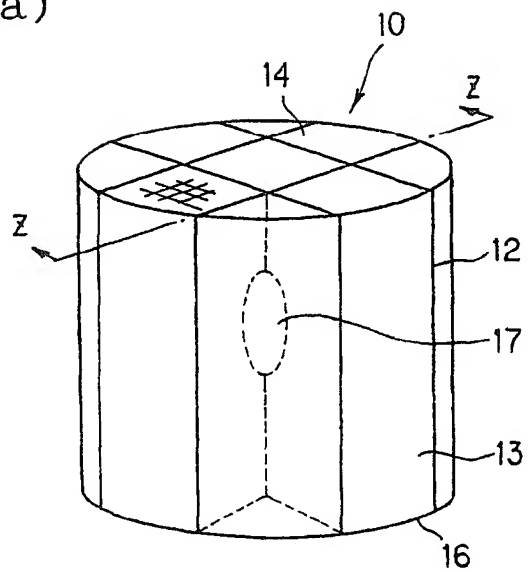


FIG. 7(b)

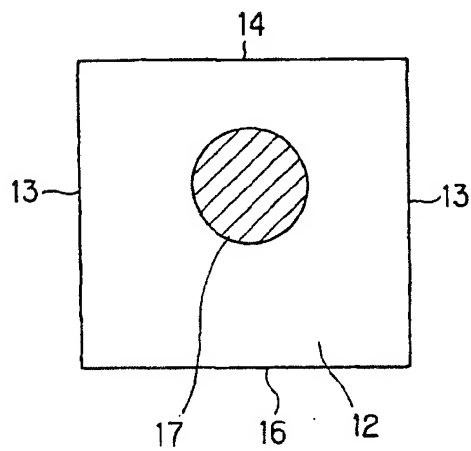


FIG. 8(b)

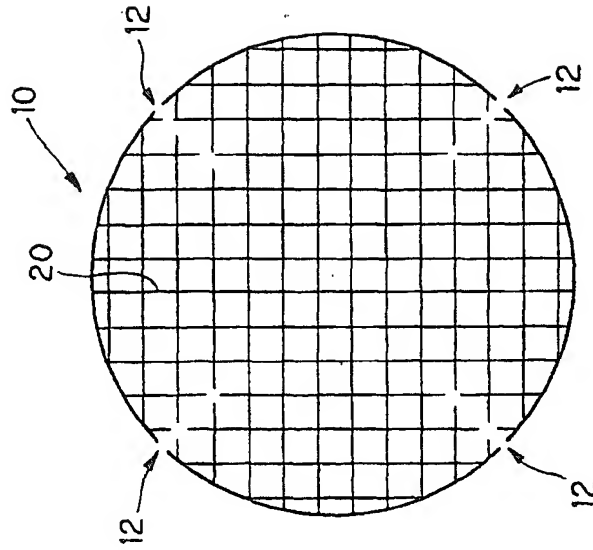


FIG. 8(a)

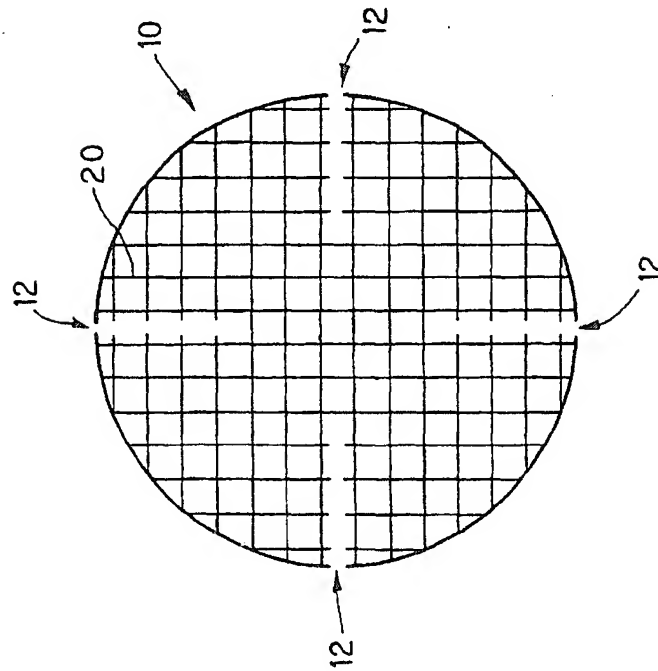


FIG. 9(a)

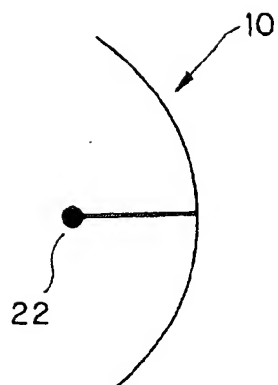


FIG. 9(b)

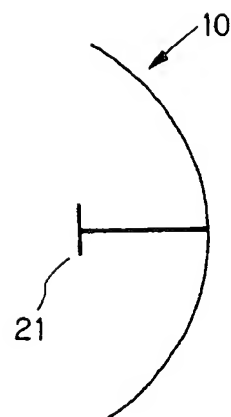


FIG. 10(b)

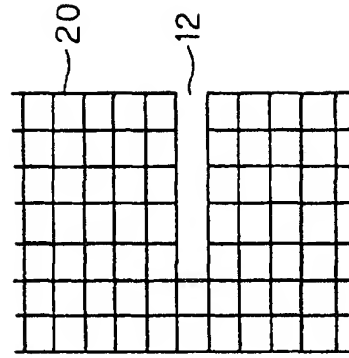


FIG. 10(a)

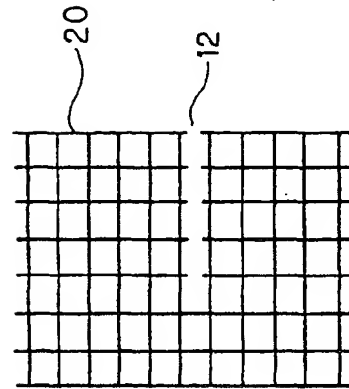


FIG. 11(a)

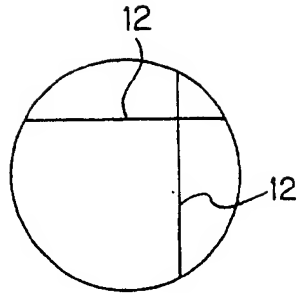


FIG. 11(b)

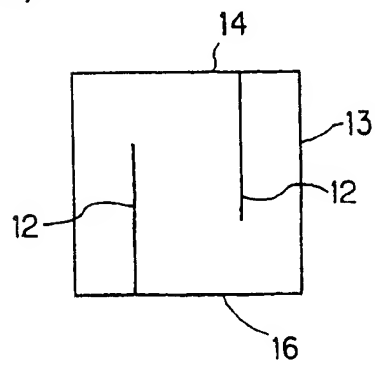


FIG. 11(c)

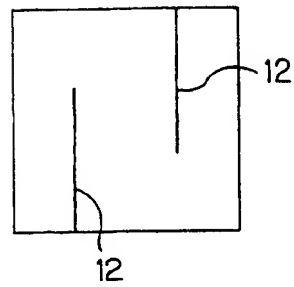
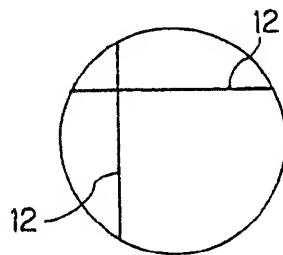


FIG. 11(d)



INTERNATIONAL SEARCH REPORT

International application No.

PCT/JP00/08044

A. CLASSIFICATION OF SUBJECT MATTER Int.Cl ⁷ B01D39/20, F01N3/02, B01J35/04, F02M27/02		
According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) Int.Cl ⁷ B01D39/20, F01N3/02, B01J35/04, F02M27/02		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched Jitsuyo Shinan Koho 1926-1996 Toroku Jitsuyo Shinan Koho 1994-2000 Kokai Jitsuyo Shinan Koho 1971-2000 Jitsuyo Shinan Toroku Koho 1996-2000		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) WPI (DIALOG)		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	JP, 50-114409, A (Asahi Glass Co., Ltd.), 08 September, 1975 (08.09.75), Figs. 1, 2; Claims; page 2, lower right column, lines 8 to 17; page 3, upper left column, line 14 to lower left column, line 7 (Family: none)	1-10, 12-18
X	JP, 3-258347, A (Matsushita Electric Ind. Co., Ltd.), 18 November, 1991 (18.11.91), Claims; page 2, upper left column, line 1 to page 3, upper right column, line 14; Figs. 1, 2 (Family: none)	1
X	CD-ROM of the specification and drawings annexed to the request of Japanese Utility Model Application No. 75486 /1991 (Laid-open No. 27215/1993) (IBIDEN CO., LTD.), 09 April, 1993 (09.04.93), claims of Utility Model; Par. Nos. [0013] to [0028]; Figs. 2 to 4 (Family: none)	1
A	EP, 787524, A1 (Corning Inc.), 09 December, 1997 (09.12.97), entire description & JP, 9-313831, A	1-18
<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C. <input type="checkbox"/> See patent family annex.		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier document but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 06 February, 2000 (06.02.00)		Date of mailing of the international search report 13 February, 2001 (13.02.01)
Name and mailing address of the ISA/ Japanese Patent Office		Authorized officer
Facsimile No.		Telephone No.

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INTERNATIONAL SEARCH REPORT

International application No.

PCT/JP00/08044

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	JP, 7-189666, A (Shimadzu Corporation), 28 July, 1995 (28.07.95), Claims; Fig. 1 (Family: none)	1-18
A	US, 5063029, A (NGK INSULATORS, LTD.), 05 November, 1991 (05.11.91), entire description; drawings & EP, 452125, A2 & JP, 3-295184, A	1-18
A	JP, 59-199586, A (NGK INSULATORS, LTD.), 12 November, 1984 (12.11.84), Claims; page 2, upper left column, line 15 to page 3, upper right column, line 11; Figs. 1-7 (Family: none)	1-18
PA	JP, 2000-153117, A (NGK INSULATORS, LTD.), 06 June, 2000 (06.06.00), Claims; Figs. 1-5 (Family: none)	1-18

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